

Work Order ID 46430

June 26, 2009 11:41:11 AM



Page 1

Item ID: D2332-041

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Lid Prop Assembly 6.69" long

Start Date: 15/07/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2332

Rev C1

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Cut D2332-7 and D2332-5 to length as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

110

0.00



Brake NC

Memo

0.00






Brake NC

Punch and form D2332-11 to length as per dwg D2332 using DT8012
(need 2 per ass'y)

Welding

Date: Wednesday, 11/03/2009 12:58:45 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LID PRO ARM ASSEMBLY (SHORT)
Job Number : 46430	
Estimate Number : 10258	
P.O. Number :	Part Number : D2332041
This Issue : 11/03/2009 S.O. No. :	Drawing Number : D2332
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : C
Previous Run : 45682	Material :
Written By :	Due Date : 30/03/2009 Qty: 12 19 Um: Each
Checked & Approved By : <u>JUD 09.03.11</u>	
Comment : Est: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/ RF Est Rev:C 08-06-02 add comment DD verified by:EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation:
Description :	
1.0	M304TR1000WO49 304 RD Tube 1.00 x .049W
	
Comment: Qty.: 0.4331 f(s)/Unit Total: 5.1975 f(s) Material: 1.000" OD x 0.049" wall SS Tube (Seamless) Batch <u>M111457</u>	
2.0	M304R250 304 SS Round bar .250
	
Comment: Qty.: 0.1092 f(s)/Unit Total: 1.3104 f(s) Material: Ø0.250" 304SS Rod Batch <u>M107139</u>	
3.0	SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1
	
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar 2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin 3-Deburr	
4.0	M304TR0500W035 304 RD Tube .500 x .035W
	
Comment: Qty.: 1.2502 f(s)/Unit Total: 15.0024 f(s) 304 RD Tube .500 x .035W	
173' 111704 (22) - 13,7520 M111097 (3) - 1,8753 M110113 (15) - 9,3765	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/03/2009 12:58:45 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

Job Number: 46430

Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012
(Note: Make (2) D2332-11 Prop Arms per assembly.)

SP 09/06/16 (19)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. (Drill 1 per assembly)
2-ensure no foreign objects inside fo tube and deburr

EP 09/06/17 (19)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

D2332-5 +17
D2332-7 +19
D2332-1 +14
D2332-11 +19

SP 09/06/18

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)
***** insure nothing is inside of tube before welding*****

A/R SS Rod Batch: M108775

*****brush weld right after welding, to take color off*****

SP 09.06.23. 19x

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.06.23

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 09/06/23 (19)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

B 9-6-24

2-Assemble as per Dwg D2332

EP 09/06/29 (19)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/03/2009 12:58:45 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

Job Number: 46430

Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN4-4A

Bolt

M108138 (52)

M111295 W4

Ep09/06/30

13.0

AN960JD416L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN960JD416L

Washer

M110153

Ep09/06/30

14.0

MS21042L4

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 MS21042L4

Nut (or -4)

M110507

Ep09/06/30

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/06/30 (19)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 512

9/6/29

(19)

SL

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

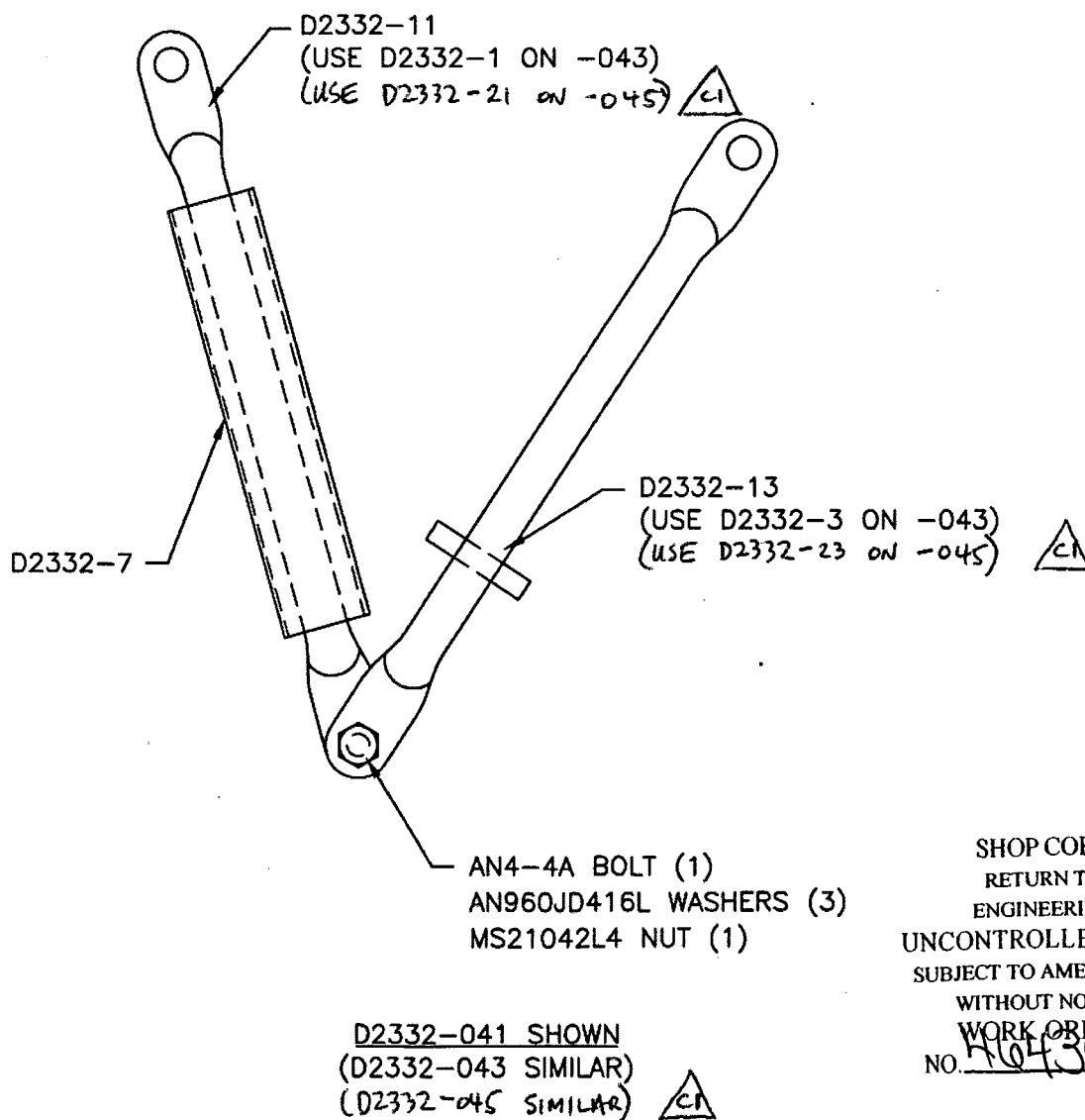
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04



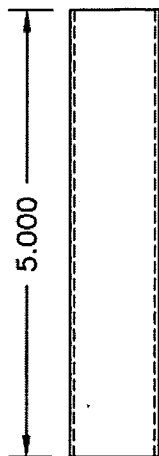
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WORK ORDER
NO. 10430

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DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2332	REV. C SHEET 2 OF 2
DATE 03.07.03				TITLE LID PROP ASSEMBLY	SCALE 1:2
C		03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT)		
C1		03.08.06	ADD -045 PROP 7.25" LONG		

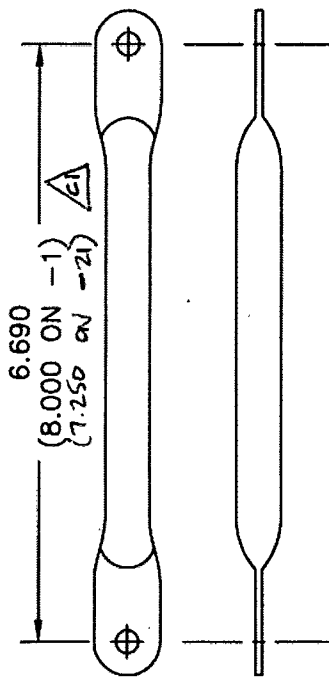


D2332-7 LOCKING COLLAR

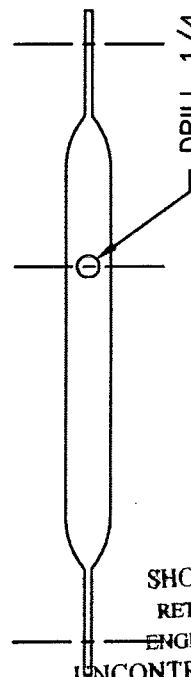
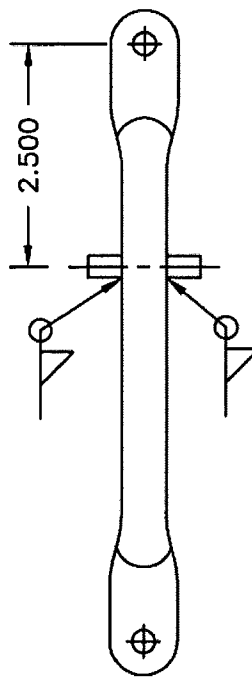
1.250



D2332-5 STOP PIN



D2332-11 PROP
(D2332-1 SIMILAR)



DRILL 1/4 HOLE FOR D2332-5

D2332-13

M/F D2332-11 & D2332-5

D2332-3 SIMILAR - M/F D2332-1 & D2332-5

D2332-23 SIMILAR - M/F D2332-21 & D2332-5



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RELEASED
03.07.04

- NOTES:
1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
 2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

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